

Date: Friday, 23/01/2009 8:47:28 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CABIN FLOOR PROTECTOR
<b>Job Number</b> : 45190	
<b>Estimate Number</b> : 12969	
<b>P.O. Number</b> :	<b>Part Number</b> : D35745
<b>This Issue</b> : 23/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3574 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 42591	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/01/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.01.23</u>	
<b>Comment</b> : Est Rev :A New Issue 07.07.23 EC verified by:JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s)  
 lexan sheet  
 Batch: 109455 B 9-2-5

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3574  
 Dwg Rev: A  
 Prog Rev: A

B 9-2-5

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 9-2-5**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK5 07/02/06 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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(4X)

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

m.l 09/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/01/2009 8:47:28 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 45190

Part Number: D35745

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/02/09 (KCB)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

MF 44928

9/2/10

(4x)

54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11 JH

Job Completion



MF 09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45190
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.001	*			
7.37	+/-0.030	7.37	✓			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
25.87	+/-0.030	25.87	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
58.38	+/-0.030	58.38	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
11.87	+/-0.030	11.87	*			
14.75	+/-0.030	14.75	*			
26.00	+/-0.030	26.00	*			
40.87	+/-0.030	40.87	*			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	*			
55.13	+/-0.030	55.13	*			
61.25	+/-0.030	61.25	*			
61.88	+/-0.030	61.88	*			
64.63	+/-0.030	64.63	*			
7.63	+/-0.030	7.63	*			
11.00	+/-0.030	11.00	*			
22.50	+/-0.030	22.50	*			
35.13	+/-0.030	35.13	*			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			

DART AEROSPACE LTD		Work Order: 45190
Description: Cabin Floor Protector		Part Number: D3574-5
Inspection Dwg: D3574	Rev: A	Page 2 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

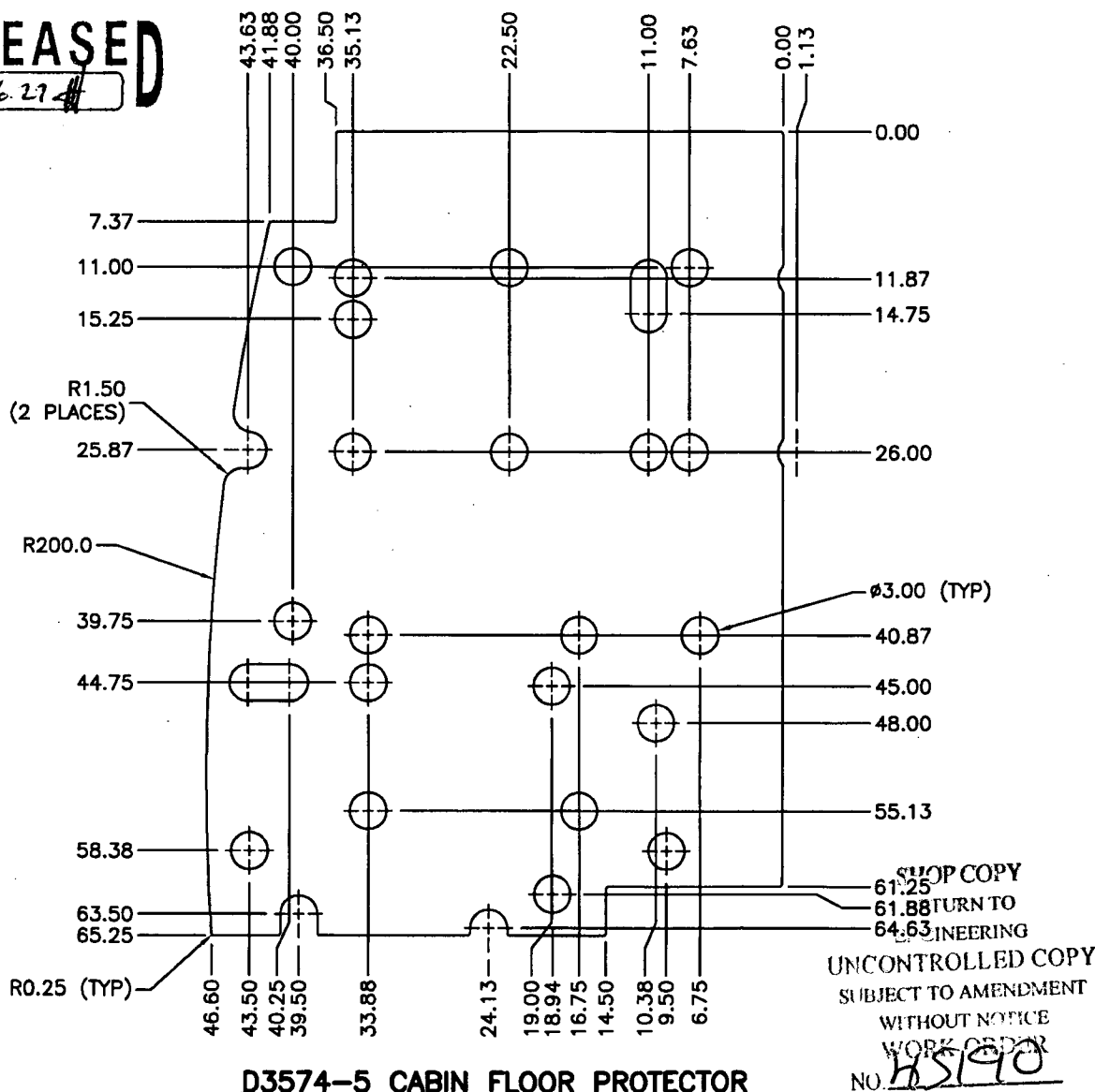
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	+/-0.030	6.75	*			
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
14.50	+/-0.030	14.50	*			
16.75	+/-0.030	16.75	*			
18.94	+/-0.030	18.94	*			
19.00	+/-0.030	19.00	*			
24.13	+/-0.030	24.13	*			
33.88	+/-0.030	33.88	*			
39.50	+/-0.030	39.50	*			
40.25	+/-0.030	40.25	*			
43.50	+/-0.030	43.50	*			
46.60	+/-0.030	46.60	*			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-2-5	Date: 09/02/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27.08**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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